

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005185**Date Inspected:** 30-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Guo gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On the date Caltrans OSM Quality Assurance (QA) inspector Mike Blair was present during the times noted above for observations relative to the work being performed.

Bay 10-Tower

Ultrasonic Testing:

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as NSD1-223A/E. The weld designations are as follows: 1

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as NSD1-61A/G. The weld designations are as follows: 6, 9

Work in progress:

This QA Inspector observed the following work in process: SAW welding of weld joint 4 located on NSD1 SA171C/D. Welder is identified as 209051. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

This QA Inspector observed the following work in process: SAW welding of weld joint 10 located on NSD1

WELDING INSPECTION REPORT

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SA171C/D. Welder is identified as 040252. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

This QA Inspector observed the following work in process: SAW welding of weld joint 30 located on NSD1 SA223C/E. Welder is identified as 250522. ZPMC QC is identified as Chen Shou Hua. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

Bay 11-Tower

This QA Inspector observed the following work in process: FCAW welding of weld joint 36 located on WSD1 SA295B/E. Welder is identified as 040713. ZPMC QC is identified as Xiao Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-Tc-P5-F.

This QA Inspector observed the following work in process: SAW welding of weld joint 12,21 located on WD1-A468-18m-1. Welder is identified as 42195. ZPMC QC is identified as Zhu Zhonghai. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3c-S-1.

This QA Inspector observed the following work in process: FCAW Gantry welding of weld joint 73-74,77-78 located on WSD1 SA225A/H. Welders is identified as 068206, 066477, 068919, and 068852. ZPMC QC is identified as Hung Li. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-Tc-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Blair, Mike	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
